

Date: Thursday, 4/5/2007 11:59:23 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET  
 Job Number : 31698  
 Estimate Number : 10348  
 P.O. Number : *N/A*  
 This Issue : 4/5/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : MACHINED PARTS  
 Previous Run : 29052  
 Part Number : D28581  
 Drawing Number : D2858 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : *N/A*  
 Due Date : 5/5/2007 Qty: 24 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est C 00.06.22 Removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

10" M6061T6B1500X01250 6061-T6 Bar 1.5" x 1.25"



Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)

Material: 1.50" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B15001250)

Batch *M101694*

*J.L 07/04/15*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 6.02"

Note: 1 Blank Makes 3 Parts

*J.L 07/04/15*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2858-

*J.L 07/04/16*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



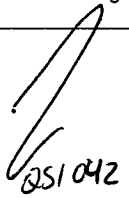



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.L 07/04/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/16	3	- 3 parts are scrapped - dimension .147 ± .010 is .131	 05/04/16	- scrap + replace - destroy	J.L. 07/04/16	 07/04/16	 05/04/16	 07/04/16

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

Job Number: 31698

Part Number: D28581

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 07-04-16 24

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

SG 07-04-16 24

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SG 07-04-16 24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

M-A 07/04/18  
(24X)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

M103706

HA 07-04-23 (24)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CP 07/04/24

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CP 07/04/24 (24)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CP 07/04/24

Job Completion



W 07-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

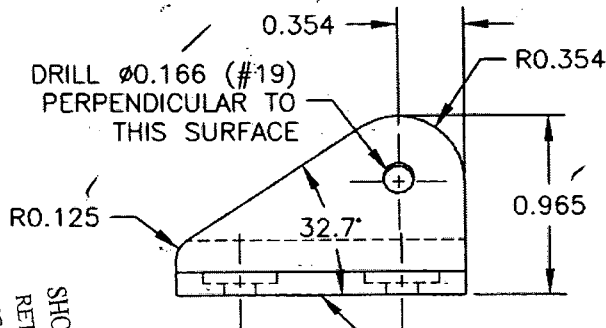
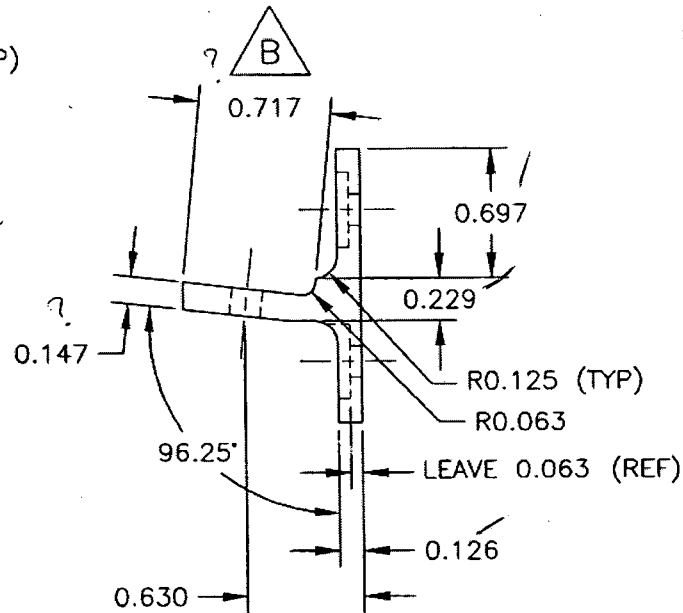
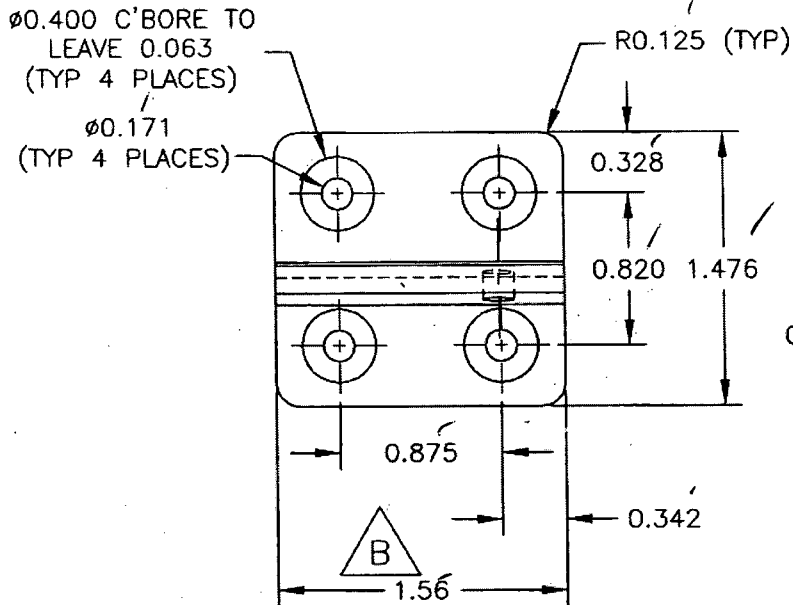
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
99.02.28 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
KE		KE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	APPROVED	KE	DRAWING NO.	REV. B
				D2858	SHEET 1 OF 1
DATE	99.02.28	TITLE	HINGE BRACKET	SCALE	1:1
A	98.12.14	NEW ISSUE			
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559			



ENGRAVE P/N CENTERED ON  
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN  
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31698
<b>Description:</b> hinge bracket		<b>Part Number:</b> D 2858-1
<b>Inspection Dwg:</b> D 2858 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.400		.400	✓			
Ø.171	+ .005 - .001	.175	✓			
r.125	+ .010	.125	✓			
.328	"	.328	✓			
.820	"	.820	✓			
1.476	"	1.477	✓			
.342	"	.341	✓			
.875	"	.875	✓			
1.560	+ .030	1.564	✓			
Ø.166	+ .005 - .001	.167	✓			
.354	+ .010	.355	✓			
.965	"	.967	✓			
r.125	"	.125	✓			
.147	"	.145	✓			
.717	"	.723	✓			
.697	"	.696	✓			
.229	"	.230	✓			
.126	"	.127	✓			
.630	"	.629	✓			
r.063	"	.063	✓			
r.125	"	.125	✓			
.063	"	.065	✓			

<b>Measured by:</b> J.L	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>
<b>Date:</b> 07/04/15	<b>Date:</b> 07.04.16	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	